

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-004549**Date Inspected:** 02-Nov-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	N/A	CWI Present:	Yes	No			
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A
Bridge No:	34-0006	Component:	OBG and SAS Tower Fabrication				

Summary of Items Observed:

On this date, Caltrans Office of Structural Material (OSM) Quality Assurance (QA) Inspector Joselito Lizardo was present as requested to perform observations on the fabrication of Orthotropic Box Girder (OBG) and SAS Tower at Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China.

Heavy Tower Bay 3:

Per ZPMC/QC request, this QA performed Initial VT on deck panel DP560-001-033~042 so ZPMC could perform grinding or repair on marked areas. On this VT revealed various weld defects i.e. overlap, underfill that were already marked by ZPMC/QC and ABF/QA.

Bay 4: Tower Diaphragm

1)This QA observed ZPMC/NDE perform MT on side plates mentioned below. This QA also performed 10% MT and VT on the same side plates.

- a)SP315-001-015~028 – deemed acceptable
- b)SP315-001-065~078 - deemed acceptable
- c)SP342-001-056~067 - deemed acceptable
- d)SP342-001-013~024 - deemed acceptable

These plates have been green tagged after finding it acceptable by all concerned parties.

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Bay 7: OBG - Floor Beam Sub Assembly

2) This QA performed VT and 10% MT on floor beams mentioned below;

- a) FB016-025-4, 10, 13, 14, 22, 23, etc. - deemed acceptable
- b) FB010-016-2, 10, 13, 14, 21, 22, etc. - deemed acceptable
- c) FB015-025-2, 10, 13, 14, 21, 22, etc. - deemed acceptable
- d) FB012-014-2, 10, 13, 14, 21, 22, etc. - deemed acceptable
- e) FB012-019-2, 10, 13, 14, 21, 22, etc. - deemed acceptable

Three of these floor beams have been green tagged while two of these floor beams still need to do MT on the other side of floor beam.

Summary of Conversations:

No significant conversation occurred today.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Joshua Ishibashi, (858) 232-7081, who represents the Office of Structural Materials for your project.

Inspected By:	Lizardo, Joselito	Quality Assurance Inspector
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Reviewed By:	Cuellar, Robert	QA Reviewer
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